



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2324-5
Job Sheet 179673



Part No: D2324-5

Job Qty: 8 ea

DAS
21
9-89

Part Name: Strap



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 KJ/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	8 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Waterjet		on 18/06/2018
100	Waterjet	8 pcs	7/18/18	7/18/18	0.00	0.29	Waterjet1		on 18/06/2018
120	QC	8 pcs	7/18/18	7/18/18	0.00	0.00	QC8		38
130	Packaging	8 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3		Spec done GA127
140	QC21-SA	8 Ea	7/18/18	7/18/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D2324

Descriptions: 130 - LOCATION : GA

DAS
21
9-89

JUN 29 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.1472 sf (.0184 ea)	90-Start up Operation	3080376

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	0	235	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	0.380Inches $\pm$ 0.030	0.410 0.350	Radius	
2	Strut	0.257Inches $\pm$ 0.006 - 0.001	0.263 0.256	Diameter	
3	Strut	0.191Inches $\pm$ 0.005 - 0.001	0.196 0.190	Diameter	
4	Strut	0.750Inches $\pm$ 0.010	0.760 0.740		
5	Strut	0.375Inches $\pm$ 0.010	0.385 0.365		
6	Strut	1.875Inches $\pm$ 0.010	1.885 1.865		
7	Strut	3.000Inches $\pm$ 0.010	3.010 2.990		
8	Strut	3.375Inches $\pm$ 0.010	3.385		

WORK ORDER NON-CONFORMANCE / UPDATE



DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
Date: _____		Step #: _____		QTY Effective: _____	
Description: _____					
Date: 06/26/18					
Completed By _____					
Lead hand / Supervisor Approval Verification _____					
QC / QA Coordinator Approval _____					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LODA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Root Cause No Re-verfic ☐ Operator ☐ Offset/Setu ☐ Supplier ☐ Training ☐ Use for Testi ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Root Cause Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Surge ☐ Pulled ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Mistread ☐ Turning Sequence ☐	
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 CANADA
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 Email: sales@dartaerospace.com
 www.dartaerospace.com

Container No: S084387
 Part: D2324-5
 Job No: 179673
 Serial No/Batch: S084387
 Revision:
 Inspector:
 Exp Date:
 Instructions:

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					